

# Work Order ID 58645

May 12, 2010 1:50:26 PM

Ship Friday 14/05



Page 1

Item ID: D3372-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Collective Lock Assembly

Start Date: 5/12/10 Start Qty: 8.00



Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D33721. Identify as D3372-3

= 7 m-d 10/05/12

8X

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/05/12 8

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Fabricate D3369-5 spacer using the flat cam as per Dwg D33691 identify as D3369-5

= 7 m-d 10/05/13

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58645

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Page 2

Item ID: D3372-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Collective Lock Assembly

Start Date: 5/12/10 Start Qty: 8.00

Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads 1 Qty Part Number Description Batch 1 A/R N/A Locktite 262 M110005 Identify as D3372-053 2-Assemble D3372-051 as per Dwg

M-12 12/05/17 (8X)  
Cpl 10-05-18

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Tack weld lock shaft as per Dwg D3372 1 Qty Part Number Description Batch 1 A/RN/A SS Rod 111679

Cpl 10-05-18

150

0.00



QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

Quality Control

(8) 10.05.15 D

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May 12, 2010 1:50:24 PM

Page 1

Work Order ID: 58645

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 5/12/10

Required Date: 5/14/10

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM  
IPP Rev:B Added Key ID 06.03.21 EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

5/16WC  
SS Flat Washer 5/16

Location	Loc Qty	Loc Code
ST377	364	
112560 ✓	364	
AN5-42A	100	Each
Purchased	54.0000	1
No		

Bolt

Location	Loc Qty	Loc Code
ST341	54	
108084 ✓	8	
108442	46	
AN960-416	100	Each
Purchased	0.0000	2
No		

Washer  
CBL-1240

Location	Loc Qty	Loc Code
ST275	435.2688	
113565	435.2688	
Cable	435.2688	0.6666
Purchased		
No		

Cable

Location	Loc Qty	Loc Code
ST275	435.2688	
113565	435.2688	
Cable	435.2688	0.6666
Purchased		
No		

Cable

16x m-l 10/05/13

8x m-l 10/05/12

16x m-l 10/05/12

N/A

h

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

May 12, 2010 1:50:25 PM

Page 2

Work Order ID: 58645

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 5/12/10

Required Date: 5/14/10

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM  
IPP Rev:B Added Key ID \_\_\_\_\_ 06.03.21 EC

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Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

CBL-460  
  
Loop Sleeve

Location	Loc Qty	Loc Code
ST284	161	
114622 ✓	161	
ST285	28	
113002	28	

N/A

16 m- 10/05/12

D2728-7  
  
Dart Logo label  
D3372-1  
  
Main Body

Manufactured No

100 Each 0.0000 0

B

B 22554

83 10/05/12

8

Manufactured No

100 Each 3.0000 1

Location	Loc Qty	Loc Code
ST485	3	
41526 ✓	3	

B 58444 (5)

3x m- 10/05/12

D3372-5  
  
Cam Lock Shaft

Manufactured No

100 Each 23.0000 1

Location	Loc Qty	Loc Code
ST052	23	
22167 ✓	18	
22290	5	

8x m- 10/05/12

May 12, 2010 1:50:25 PM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

May 12, 2010 1:50:25 PM

Page 3

Work Order ID: 58645

Parent Item: D3372-041

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Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D3372-7  
Slider Body

Location

ST485

Loc Qty

6

Loc Code  
B 58439

(24)

6x m-l 10/05/12

D3373-1  
Cam Lock

Manufactured No

100

Each

9.0000

Location

ST052

Loc Qty

9

Loc Code  
B 58463

1x m-l 10/05/17  
7x m-l 10/05/12

D3384-1  
Cyclic Sock

Manufactured No

100

Each

3.0000

Location

ST486

Loc Qty

3

Loc Code

1x m-l 10/05/12  
2x m-l 10/05/12

HX-81  
1/4"-20 SHCS 3/8" long

Purchased No

100

Each

64.0000

Location

ST390

Loc Qty

64

Loc Code

8x m-l 10/05/12

110383

114383

14

50

Batch: B 57807

m-l 10/05/17

B 58670

Shop Packet Print

(B) 4 8x 10/05/12

10.05.13

A3384-043

May 12, 2010 1:50:25 PM

Page 3

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

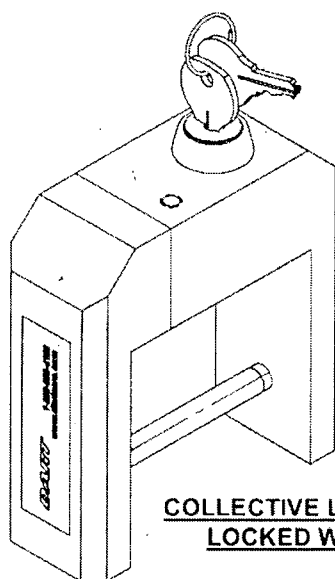
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

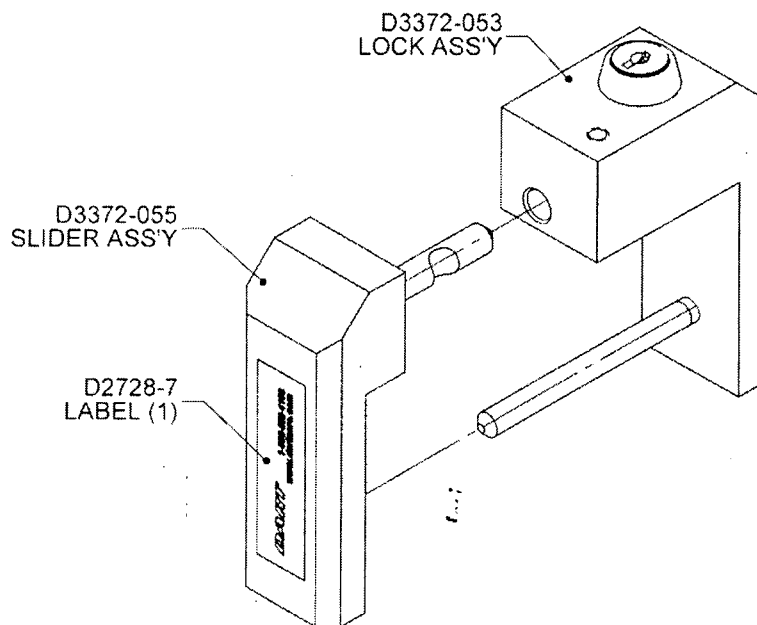
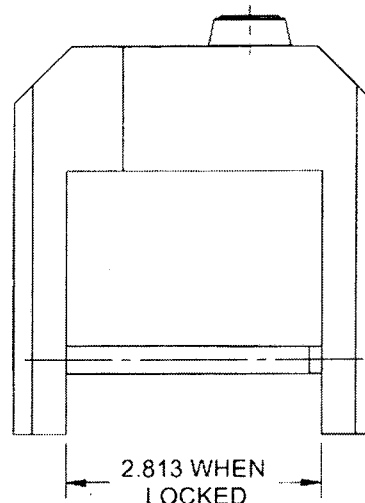
NOTE: Date & initial all entries



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DATE	05.02.23	TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



**D3372-051 AS350 COLLECTIVE LOCK ASS'Y**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

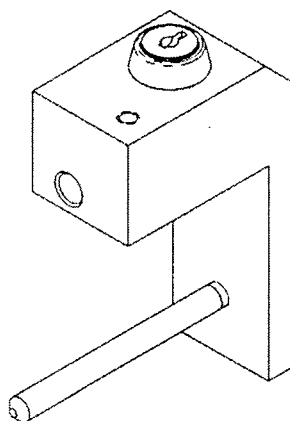
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

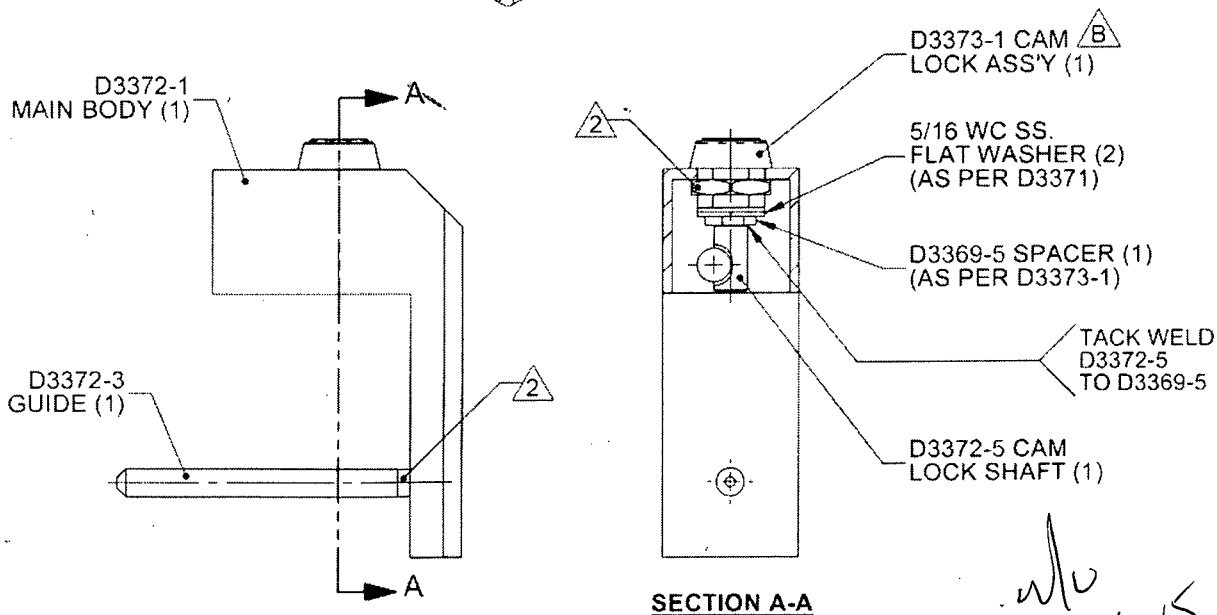
**NOTE:** Date & initial all entries



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED MD	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2



RELEASED  
20/04/23



WV  
58645

### D3372-053 LOCK ASS'Y

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

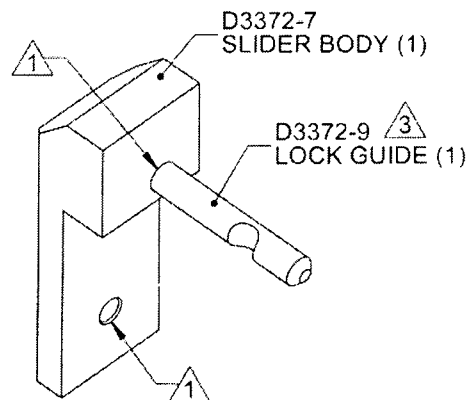
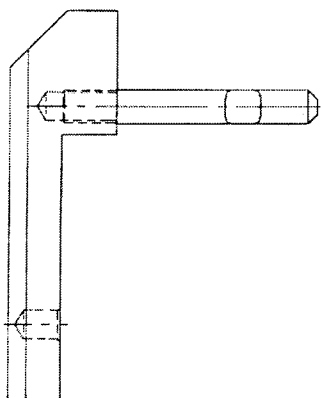
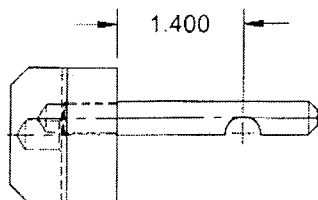
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 3 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



**D3372-055 SLIDER ASS'Y**

**NOTES:**

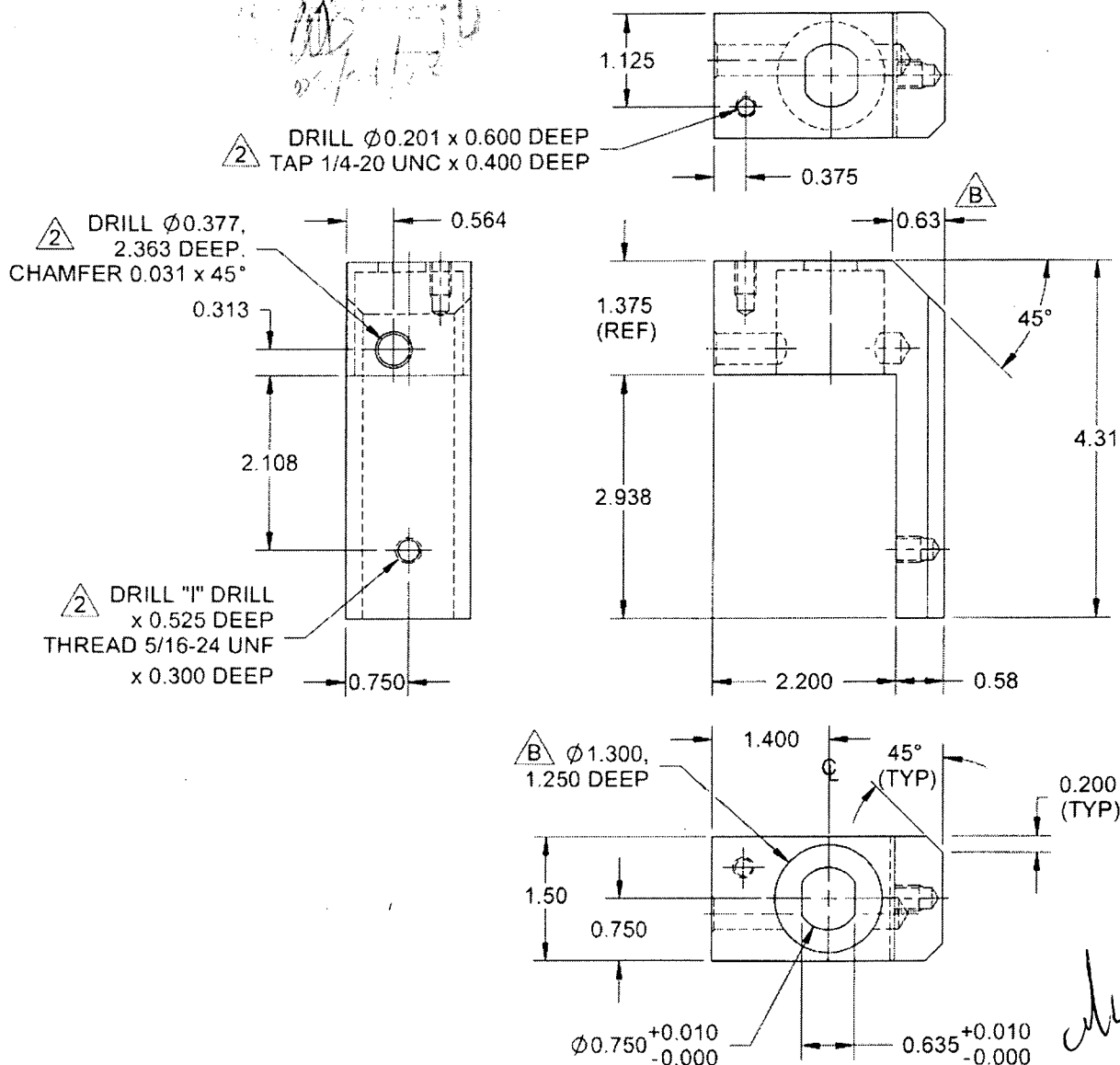
- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



### D3372-1 MAIN BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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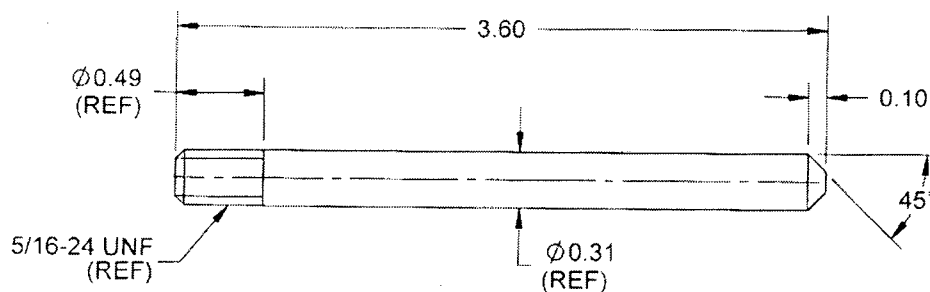
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

## SPECIFICATION CONTROL DRAWING



### D3372-3 GUIDE

#### NOTES:

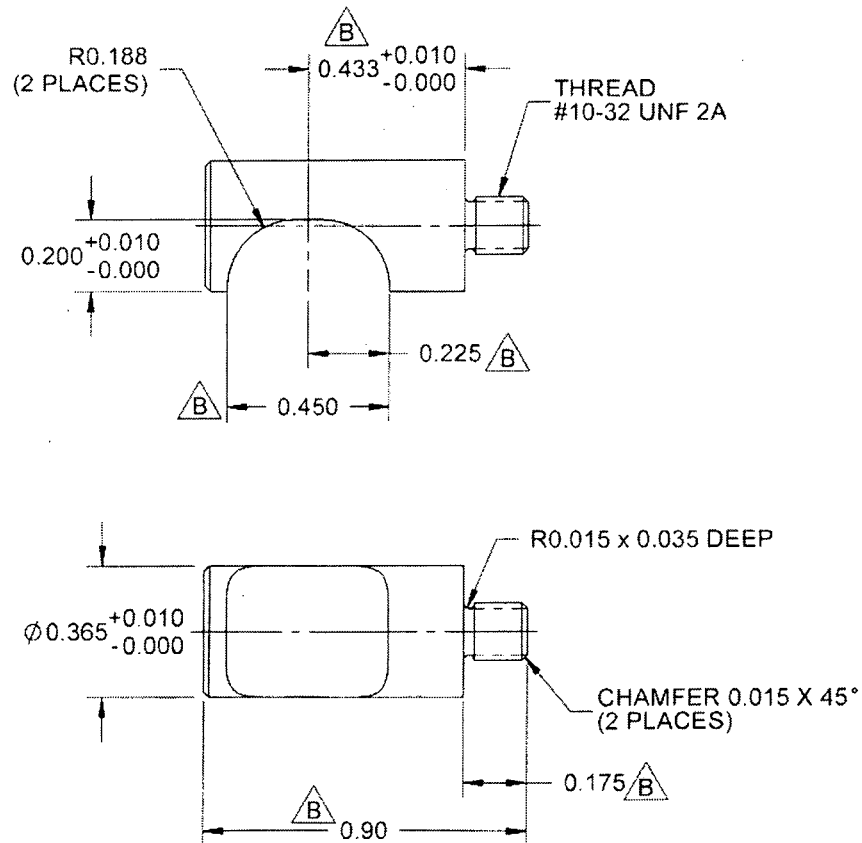
- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED 7	APPROVED 7	DRAWING NO. <b>D3372</b>	REV. B SHEET 6 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 2:1



### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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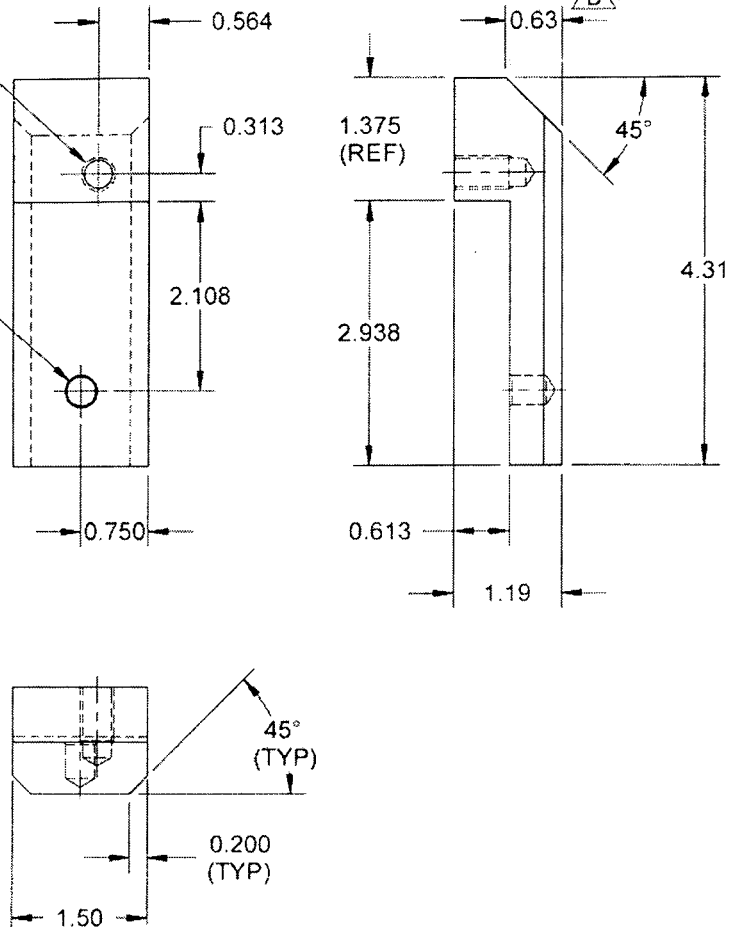
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 7 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

DRILL  $\phi 0.332$   
("Q" DRILL) x 0.881 DEEP,  
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL  $\phi 0.323$   
("P" DRILL) x 0.500 DEEP  
CHAMFER 0.030 x 30°



### D3372-7 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

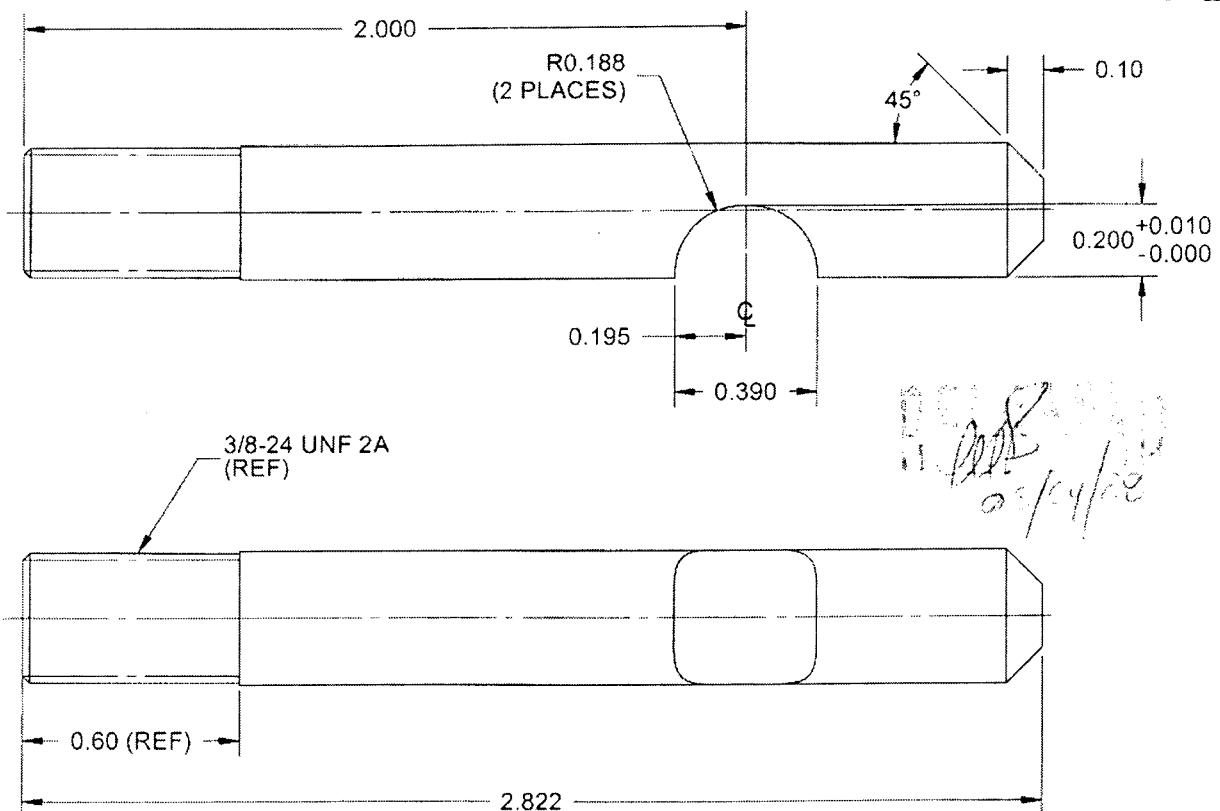
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CHECKED 13	APPROVED 13	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

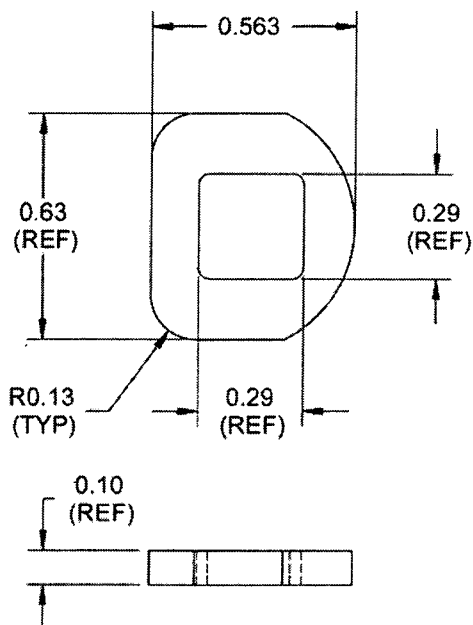
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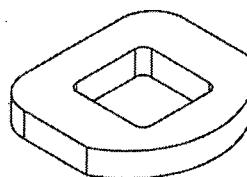
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16	TITLE BATTERY LOCK		SCALE 2:1

## SPECIFICATION CONTROL DRAWING



RELEASED  
*[Signature]*

05/02/11



# 58645

- 5  
**D3369 SPACER**



### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries